

Date: Monday, 8/21/2006 2:13:38 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : MOUNTING LUG
 Job Number : 28272
 Estimate Number : 10428
 P.O. Number : N/A Part Number : D32351
 This Issue : 8/21/2006 S.O. No. : N/A Drawing Number : D3235 REV A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : A
 Previous Run : 27866 Material : N/A
 Due Date : 9/8/2006 Qty: 100 Um: Each
 Written By :
 Checked & Approved By : 06.08.21
 Comment : Est A 04.04.19 New issue KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0717 f(s)/Unit Total: 7.1715 f(s)

Lug Extrusion

D2423 extrusion

Batch: B23777

En 06/09/14 x100

2.0 BAND SAW BAND SAW



Comment: Band Saw

Cut D2423 extrusion to 0.820"

Batch: B23777

En 06/09/11 x100

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1

RG



Issue 8.0 2002



C 06/09/12

Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA369 and Dwg D3235

2-Identify as D3235-1

3-Deburr and Tumble

machine per drug D3235 Rev A

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

RG



Receive + Inspect for



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

transit damage / 06/9/29

5.0 QC6 SECOND CHECK



06.10.03



Comment: SECOND CHECK

counted 100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 06/10/10

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 8/21/2006 2:13:38 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 28272

Part Number: D32351

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

YJ 06/10/05 X 100

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

J 06.10.05 (100)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

a.m YJ 06/10/05 X 100

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

P 6/10/06 (100)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST94 *P* 6/10/06 (100)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

200
S 06/10/10

Job Completion



W 06.10.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order: 28272
Description: Mounting Lug		Part Number: D3235-1
Inspection Dwg: D3235	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.450	+/-0.010					
0.306	+/-0.010					
1.85	+/-0.030					
R1.20	+/-0.010					
R0.125	+/-0.010					
0.400	+/-0.010					
0.735	+/-0.030					
Ø0.505	+0.005/-0.000					
R0.38	+/-0.030					
3.700	+/-0.005					
0.375	+/-0.010					
0.750	+/-0.010					
Ø0.257	+0.005/-0.000					
R0.380	+/-0.030					

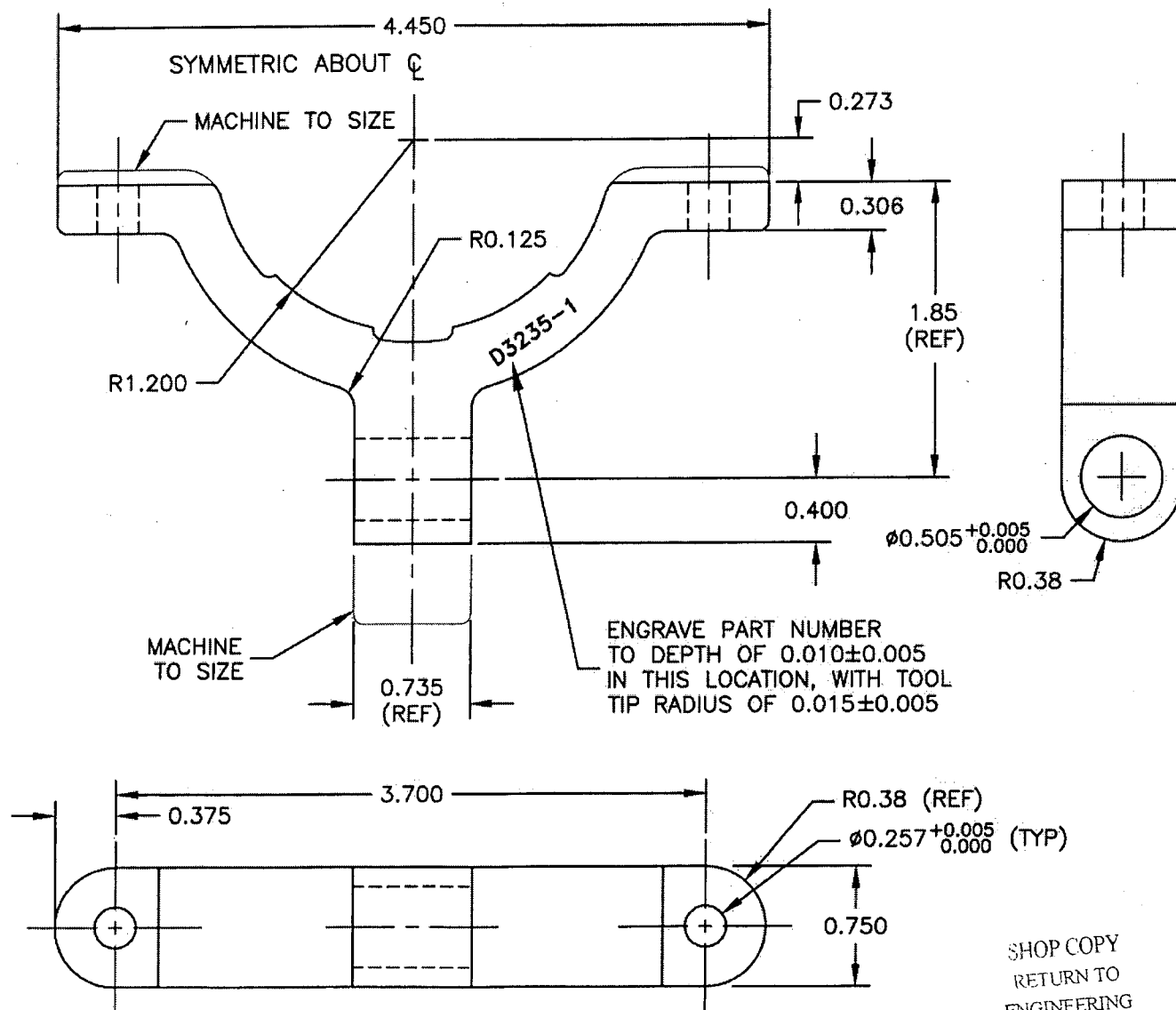
Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue	KJ/JLM	



DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3235	REV. A SHEET 1 OF 1
DATE 04.03.02		TITLE MOUNTING LUG	SCALE 1:1
A	04.03.02	NEW ISSUE	

RELEASED
04.04.05 *#*



D3235-1 MOUNTING LUG

MAKE FROM EXTRUSION D2423

BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28272

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CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>MATERIAL BATCH NUMBER</u>	<u>P.O. NUMBER</u>
100 ✓	D3235-1 ✓	Mounting Lug	D2423 B23779 ✓	2002 ✓

MATERIAL: supplied by DART

A handwritten signature in black ink, appearing to be a stylized 'Z' or 'R'.

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink, appearing to be "Denise Robinson".

Denise Robinson

Vankleek Hill, September 28, 2006